

Blue

Dart Aerospace Ltd.

Date: Wednesday, 12/11/2008 1:41:16 PM  
 User: Julie Dawson

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BLUE - LUG EXTRUSION  
 Job Number : 43389 - 2  
 Estimate Number : 10326  
 P.O. Number :  
 This Issue : 12/11/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D27317  
 First Issue : 11 Type : MACHINED PARTS Drawing Number : D2731 REV B  
 Previous Run : 42568 Drawing Revision : B  
 Written By : Due Date : 10/12/2008 Qty: 100 Um: Each  
 Checked & Approved By : JUD 08.11.12  
 Comment : Est D 00.05.19 Added inspect level 8, removed P/O powder coating EC

Additional Product

Split 2

Job Number: 

Seq. #: Machine Or Operation: Description :

1.0 D2423 Lug Extrusion



Comment: Qty.: 0.0717 f(s)/Unit Total: 7.1715 f(s)

Lug Extrusion D2423

Batch: B43722

2.0 BAND SAW BAND SAW



Cut @ meter

Comment: BAND SAW

Cut D2423 extrusion to .82"

Batch

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



P/O: 7584 C20811114

Issue P/O meter

Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per folio D2731-7.

2-Check for crack while loading into the machine.

3-Tumble

4-Debur any rough edges after tumbling

Machine as per drawing

4.0 Q02 INSPECT PARTS AS THEY COME OFF MACHINE



rec'd.

rec'd + inspect for transit damage

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

attached c+c

9/6/12 (100)

5.0 Q08 SECOND CHECK



Comment: SECOND CHECK

8026108

counts (100)

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLUE - LUG EXTRUSION

Job Number: 43389

Part Number: D27317

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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(100)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FL 02/01/12

7.0	SPRAY PAINTING	SPRAY PAINTING
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Comment: -PRIME B 110199

-PAINT DELFLEET BLUE B 110077

-CLEAR DELFLEET B 110166

25 09-01-29

+ 48

8.0	QC14	INSPECT SPRAY PAINT
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10902.02

Comment: INSPECT POWDER COAT

48

9.0	PACKAGING 1	PACKAGING RESOURCE #1
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48x

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

01212

SP

10.0	QC21	FINAL INSPECTION/W/O RELEASE
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09/02/09

Comment: FINAL INSPECTION/W/O RELEASE

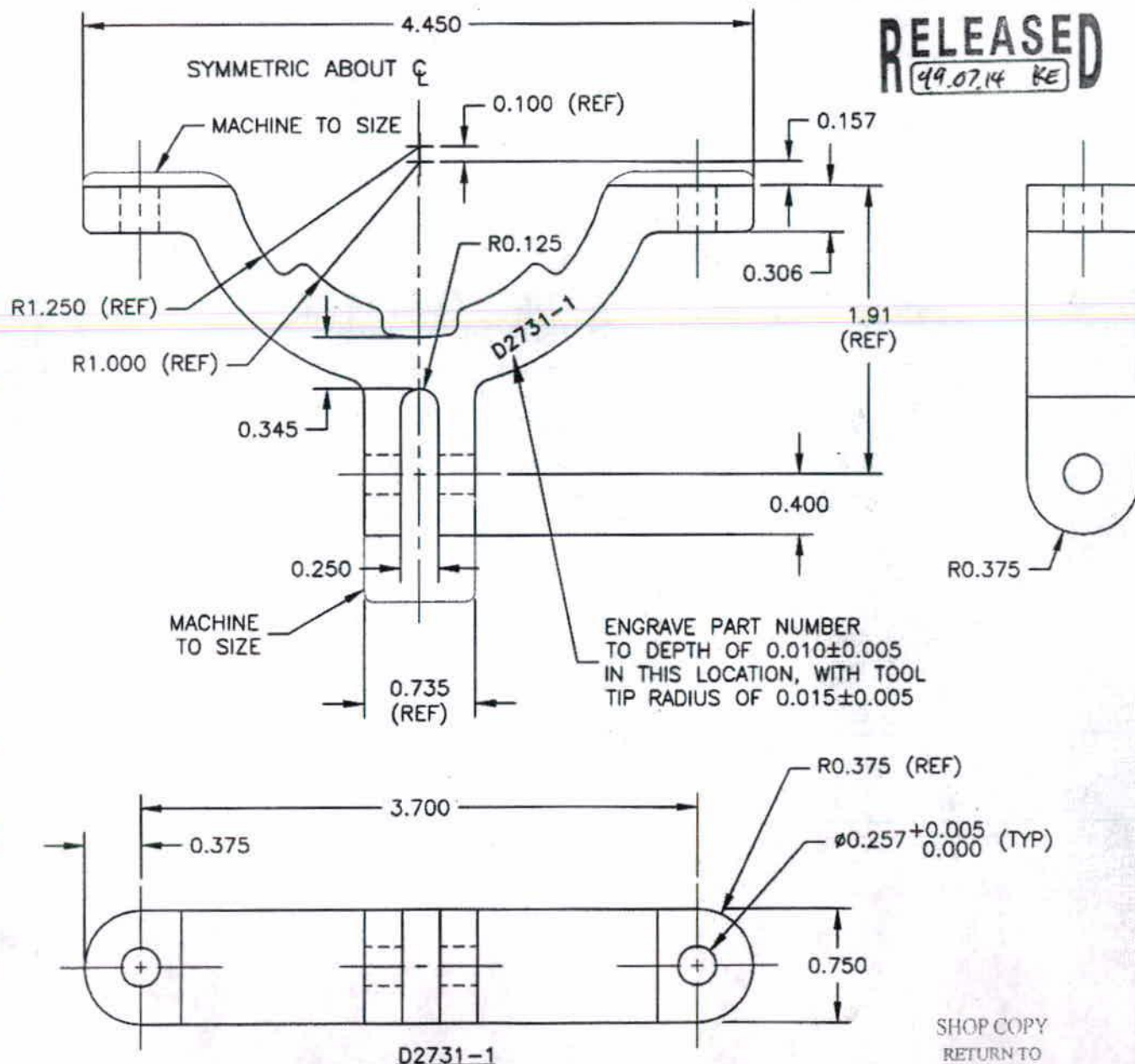
Job Completion



MF  
09-02-09

**DART**

DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2731	REV. B SHEET 1 OF 4
DATE 99.07.06		TITLE MOUNTING LUG	SCALE 1:1
A	98.05.13	NEW ISSUE	
B	99.07.06	REVISED DIMENSIONS	

**RELEASED**  
49.07.14 KE

MAKE FROM EXTRUSION D2423  
BREAK ALL EDGES 0.000-0.015  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
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WITHOUT NOTICE

WORK ORDER  
42389